

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	



RELEASED
05.11.23

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

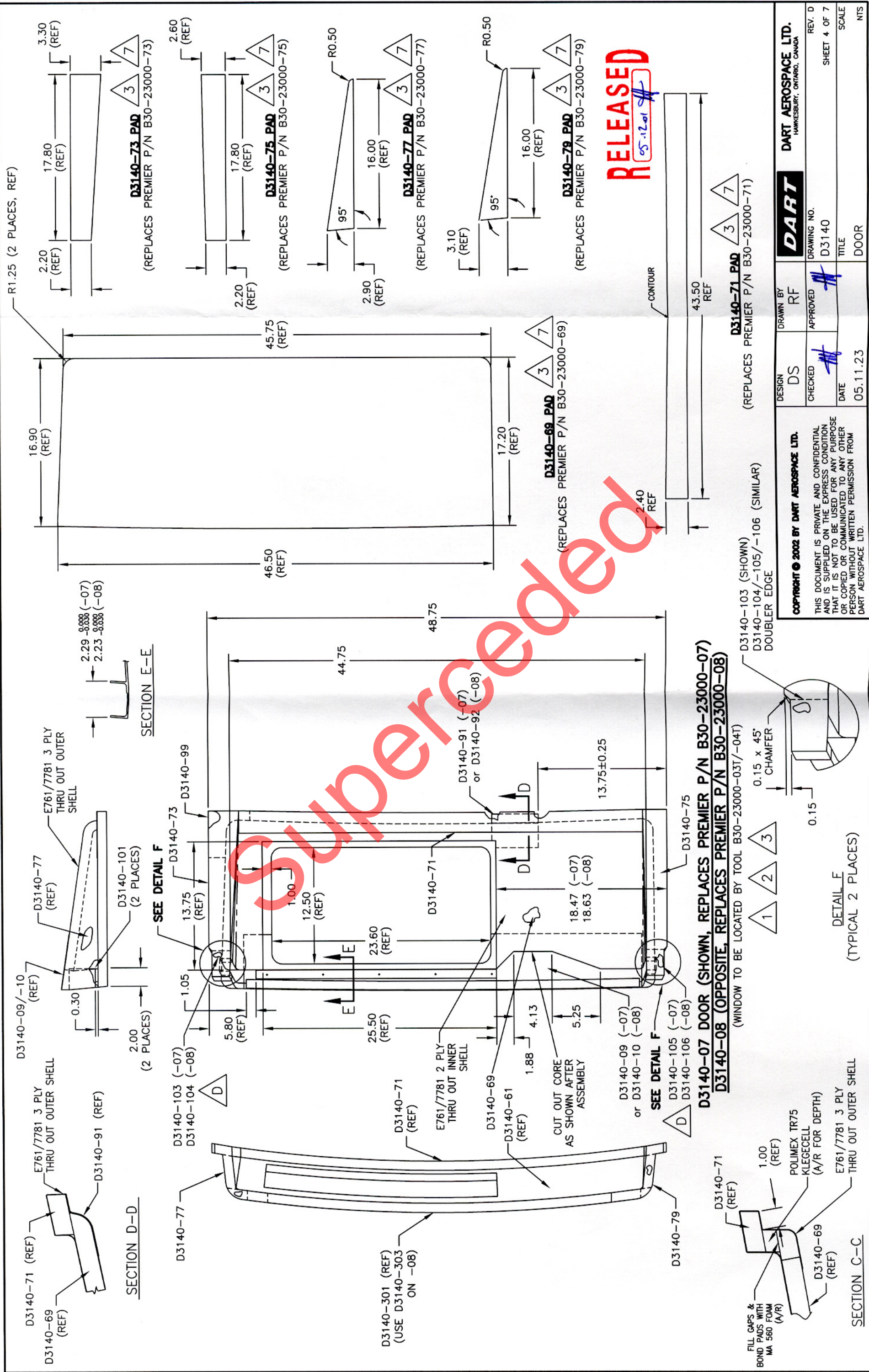
DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

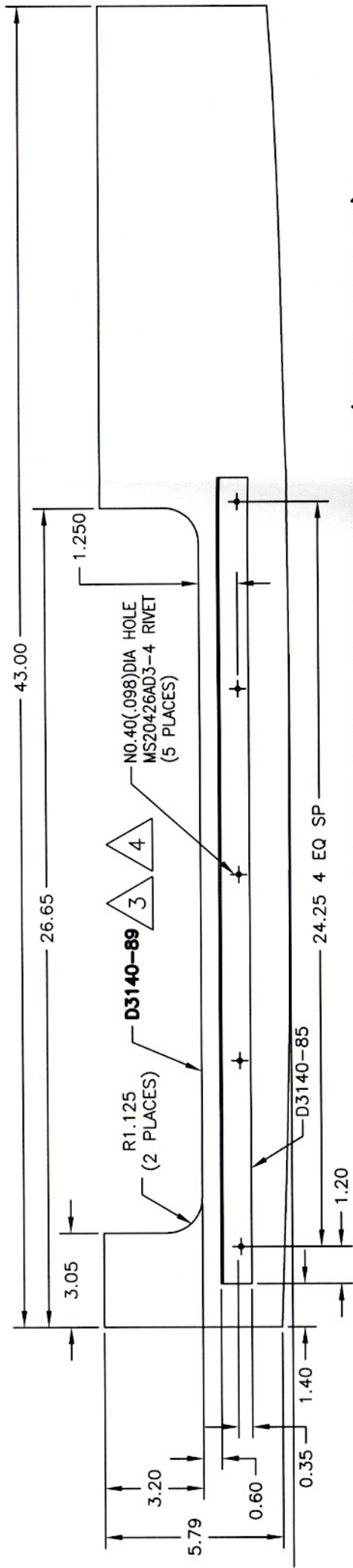
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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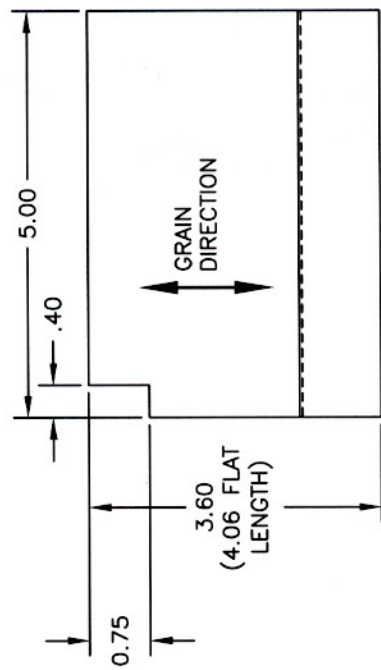
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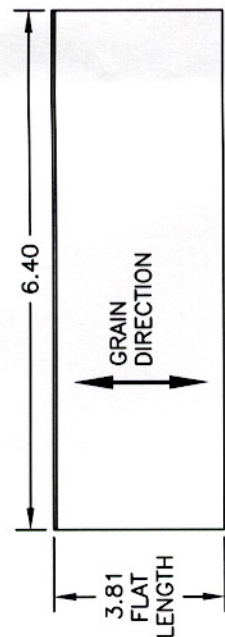


D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

D3140-101 DOUBLER (REPLACES PREMIER P/N B30-23000-101)



D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

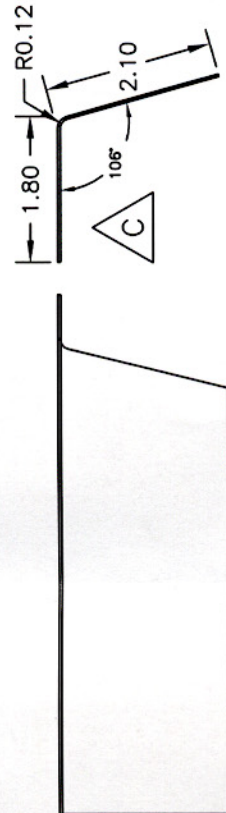


D3140-95 DOUBLER (REPLACES PREMIER P/N B30-23000-95)

D3140-91 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

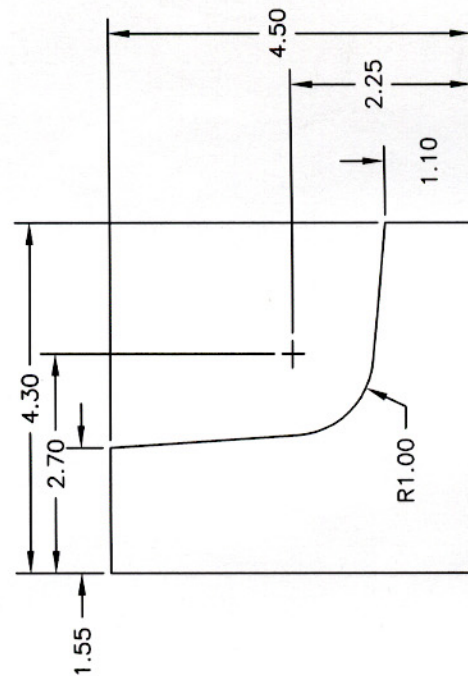


D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)



BEND DETAIL

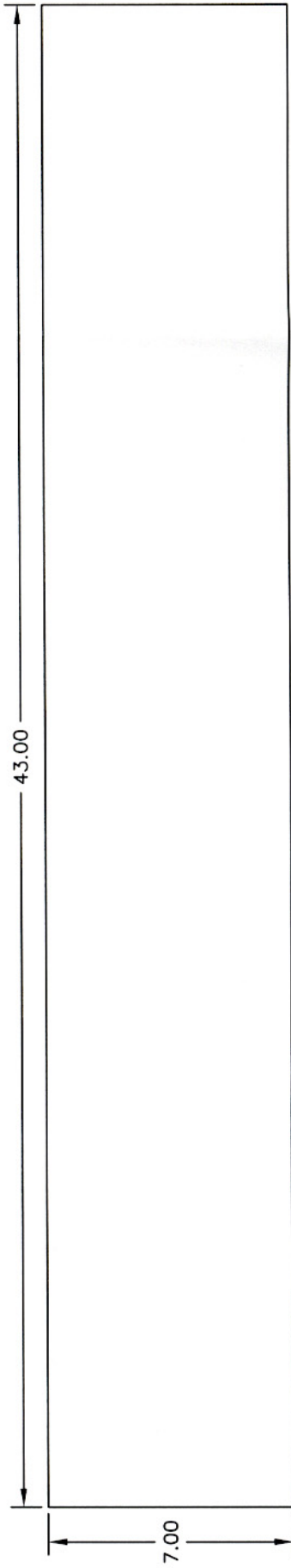
D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



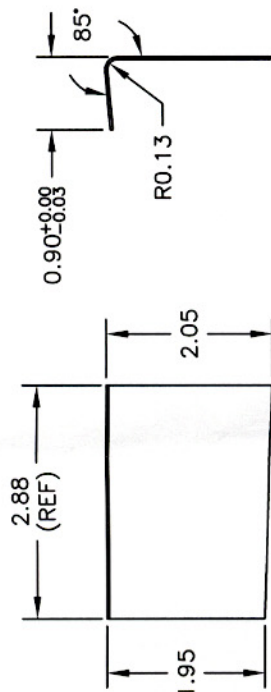
D3140-99 DOUBLER (REPLACES PREMIER P/N B30-23000-99)

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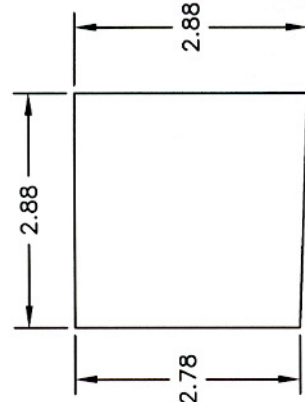
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		SCALE	NTS



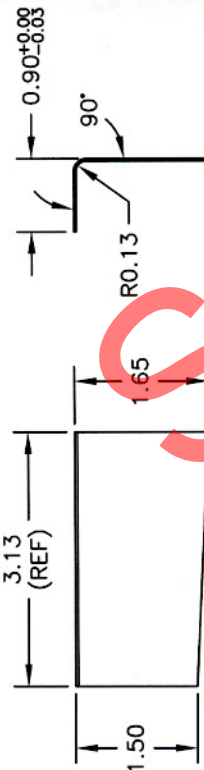
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



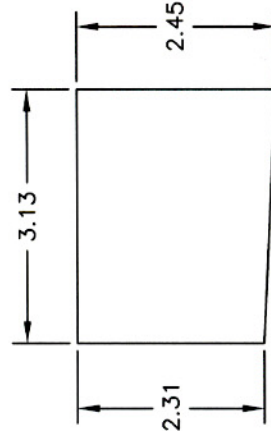
D3140-103 DOUBLER
D3140-104 OPPOSITE



D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

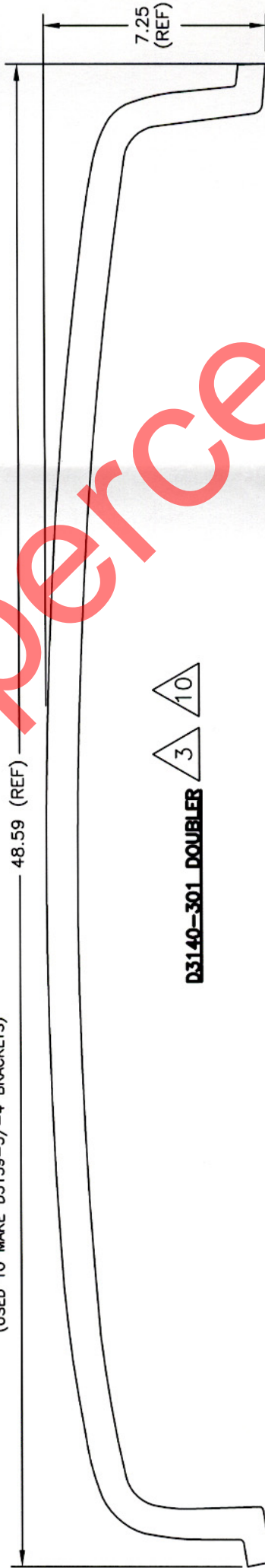


D3140-105 DOUBLER
D3140-106 OPPOSITE

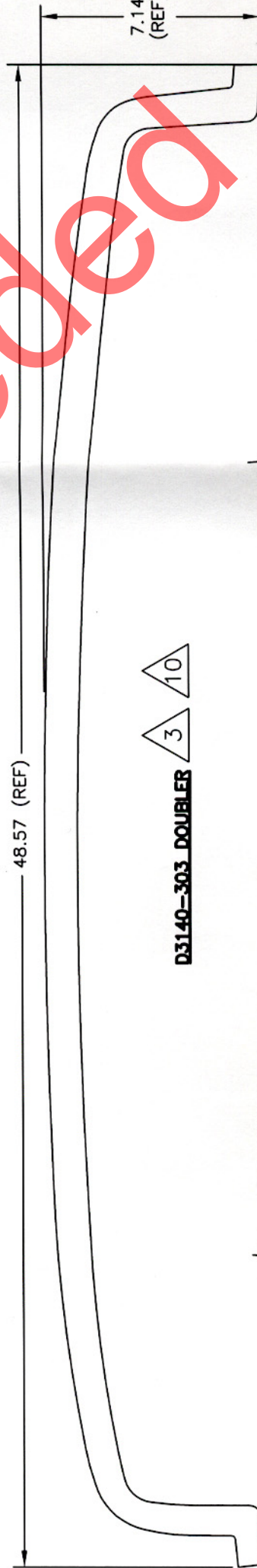


D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

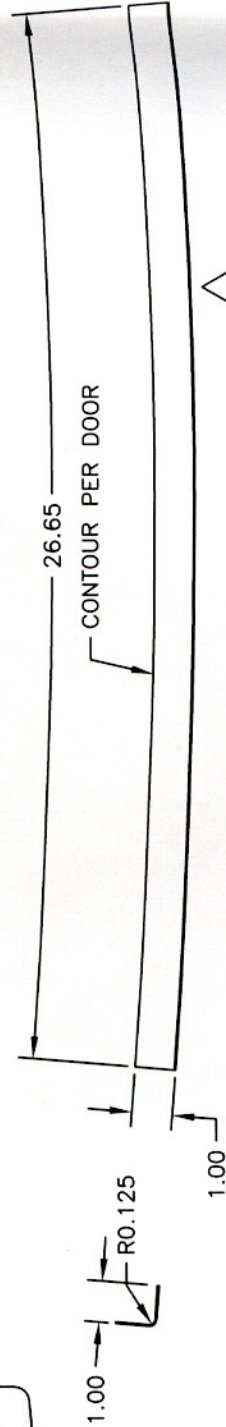
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



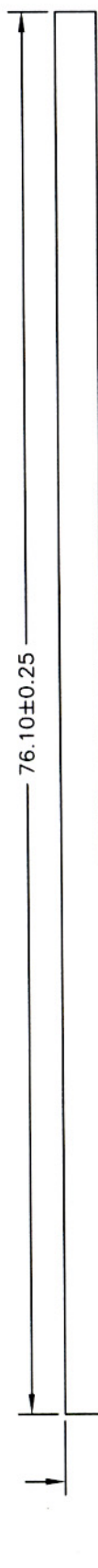
D3140-303 DOUBLER



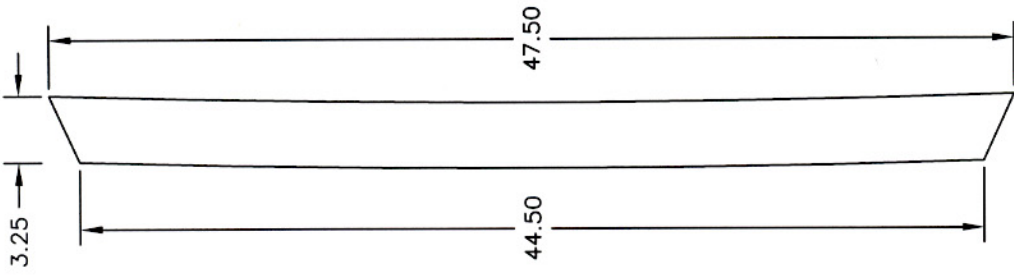
D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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05.12.01

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DESIGN DS	DRAWN BY RF	DRAWING NO. D3140	REV. D
CHECKED [Signature]	APPROVED [Signature]	TITLE DOOR	SHEET 6 OF 7
DATE 05.11.23			SCALE NTS



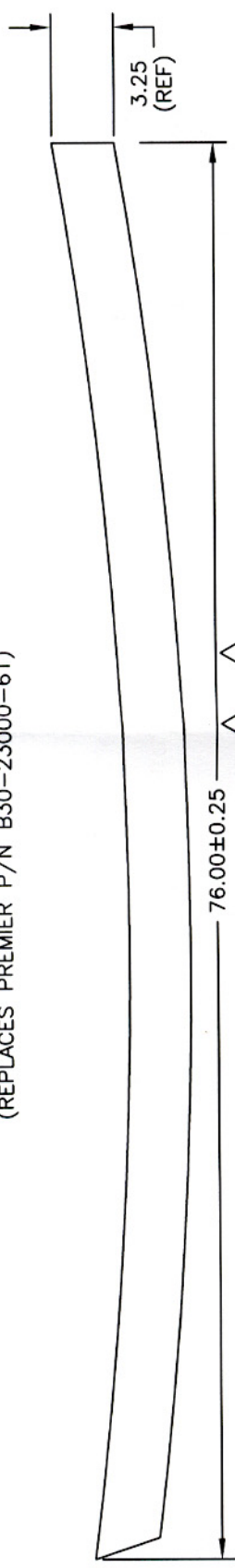
D3140-61 PAD
(REPLACES PREMIER P/N B30-23000-61)



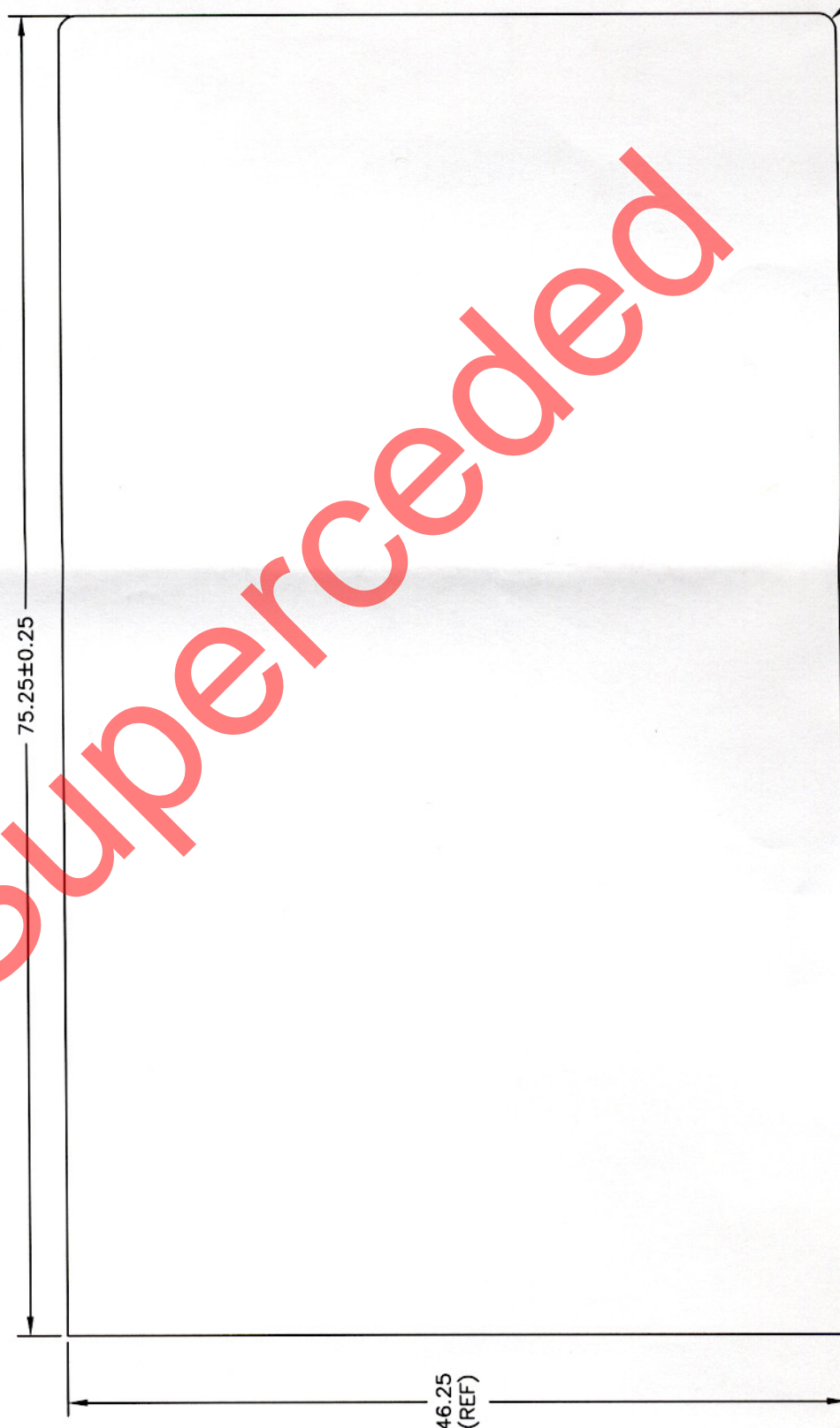
D3140-241 DOUBLER
(REPLACES PREMIER P/N B30-23000-241)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)



D3140-63 PAD
(REPLACES PREMIER P/N B30-23000-63)



R1.00
(2 PLACES, REF)

D3140-59 PAD
(REPLACES PREMIER P/N B30-23000-59)

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		CHECKED	APPROVED	D3140	SHEET 7 OF 7
		DATE		TITLE	SCALE
		05.11.23		DOOR	NTS